

Work Order ID 77032

77032

Page 1

November-24-11 3:39:25 PM

Item ID: D3659-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: CUFF
 Start Date: 24/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.LJ Date: 4/11/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3659	Rev B

100 0.00
100 BAND SAW
 Bandsaw Memo
 Jeaspa Bandsaw Cut blank 7.300" long
0.00 ok 12/02/15 10 ✓

110 0.00
110 DOOSAN LATHE
 Doosan Memo
 Doosan Lathe 1-Turn as per folio FA 707 & DWG D3659
 FOLIO REV: B
 DWG REV: 12/2/15
 2-Deburr as required
0.00 12/2/15 11 ✓

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo
 Quality Control
0.00 12/2/15 11 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									

140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

mk 12/02/16

11 OK 12-2-17

11X of M-L 12/02/17

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>482</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

Handwritten notes:
12/2/22 sf 11/12
M.C.J 12/02/23
R1202-23

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Picklist Print

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77032

Parent Item: D3659-1

D3659-1

Parent Item Name: CUFF

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A new issue 07.09.19 EC verified by:JLM
IPP Rev:B 08-04-07 chg to revB DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6009-129		Manufactured	No			100	Each	6.0000	0.619	6.515789			
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D6009-129

Crosstube Material

**

Handwritten: 12/2/15

Location

Loc Qty

Loc Code

LG

6

65179

6

Handwritten: D6008

Handwritten: B46779

Handwritten: * Leftover scrap X-Tube Material

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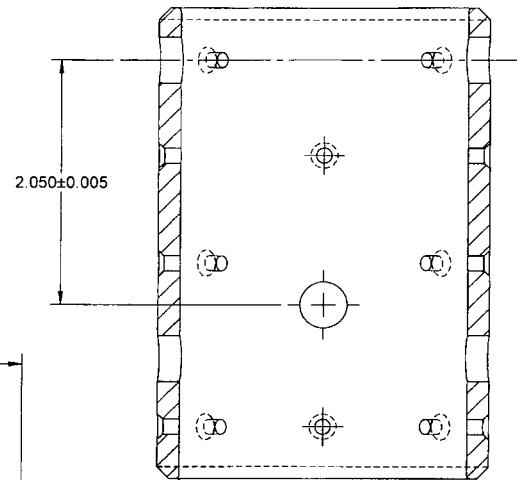
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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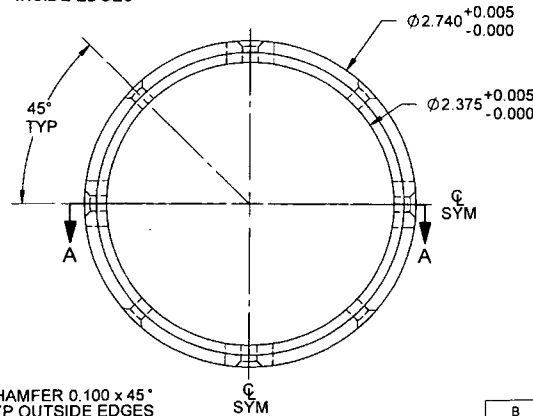
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 77032 M.C.J
11/11/24



SECTION A-A

R0.032 TYP
INSIDE EDGES



CHAMFER 0.100 x 45°
TYP OUTSIDE EDGES

D3659-1 CUFF

DRILL #30 (Ø 0.128 REF)
C'SINK Ø 0.230 x 100°
TYP 22 PLACES

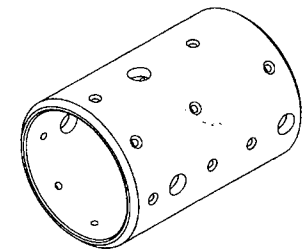
B

Ø 0.386 ^{+0.005}/_{-0.000}
HOLE TO BE ALIGNED
WITHIN ± 0.001 OF HOLE
ON OTHER SIDE OF CUFF,
TYP 6 PLACES

B

NOTES:

- 1) MATERIAL: 7075-T6/T6511 SEAMLESS TUBE (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6005, D6006, D6008, D6009, D6011, OR D6019)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.56 lbs



B	ADD Ø 0.128 & Ø 0.386 HOLES (B8)	CP	08.03.03
A	NEW ISSUE	CP	07.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.03.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3659	REV. B
TITLE CUFF	SCALE NTS
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